

# Work Order ID 120843

June-11-14 2:47:29 PM

**\*120843\***

Page 1

Item ID: D3836-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib Assembly (Basket Lid, LH)  
 Start Date: 6/11/14 Start Qty: 8.00 **\*9\*** Cust Item ID:  
 Required Date: 6/11/14 Req'd Qty: 8.00 **\*4x\*** Customer:  
 Reference:

Approvals: Process Plan: MW Date: 14-06-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3836	C								

100 -0.00  
**\*100\*** Large Fab  
 Large Fab Memo 0.00  
 Large Fab  
 1- cut D3836-1 and D3836-3 rib as per dwg D3836. USE DT9827 TO TRACE D3836-3  
 2- remove identification markings  
 3- deburr  
 4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836  
 5- c-sink holes for ~~D3836-1~~ 4021-9 bushing  
 6- weld D2327-3 spacer bushing and bushings as per dwg D3836  
 A/R ER316 S.S. Rod Batch: 6123823  
 7- grind weld flush where indicated on dwg

4x CC 14-6-12

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Stop \*NR2\*

## Packaging

Work Order ID 120843

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\*120843\*

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Item ID: D3836-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/11/14

Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 6/11/14

Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

MLJ 14-06-18

14-6-17

# Picklist Print

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Page 1

Work Order ID: 120843

**\*120843\***

Parent Item: D3836-041

**\*D3836-041\***

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/11/14

Required Date: 6/11/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC IPP REV:B  
12.07.24 AS PER REV.B DD VERF:EC IPP REV:C 12.08.08  
AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured No

100

Each

70.0000

1

8

**\*D2327-3\***

Spacer Bushing

**\*\***

CC 14-6-12

Location

Loc Qty

Loc Code

WA004

70

100523

35

103679

35

4x

D4021-9

Manufactured No

100

Each

318.0000

2

16

**\*D4021-9\***

Bushing

**\*\***

CC 14-6-12

Location

Loc Qty

Loc Code

WA004

318

107634

22

116010

132

116663

64

117495

100

8x

M304TS0.750W.065

Purchased

No

100

f

1,774.915

1.7808

15

**\*M304TS0 750W 065\***

304 SQ Tube .75x.75x.065W

**\*\***

CC 14-6-12

Location

Loc Qty

Loc Code

WA004

1774.915

125513

557.515

m126538

402

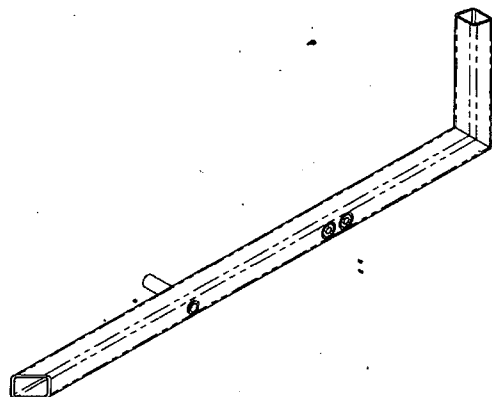
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215.4

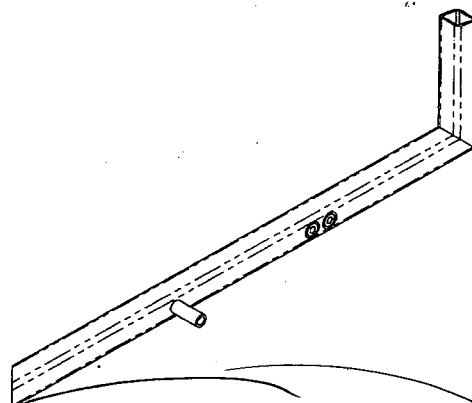
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600

8x



**D3836-042 RIB ASSY (BASKET LID, RH)**



**D3836-041 RIB ASSY (BASKET LID, LH)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.02 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3836-041	RIB ASSY (BASKET LID, LH)
		X	D3836-042	RIB ASSY (BASKET LID, RH)
1	1	1	D2327-3	SPACER BUSHING
2	1		D3836-1	RIB
3		1	D3836-2	RIB
4	1	1	D3836-3	RIB
5	2	2	D4021-9	BUSHING

SHOP COPY  
RETURN TO  
ENGINEERING.  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 120843.MCJ  
1406-11

**RELEASED**  
2012-08-03

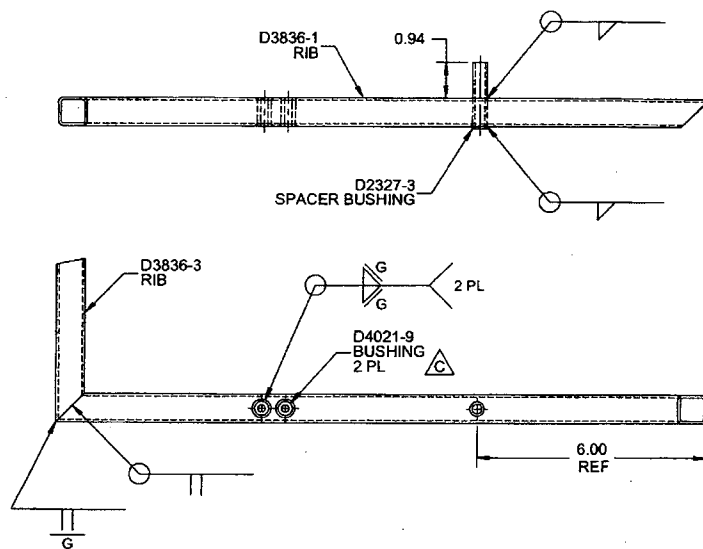
C	D4021-9 WAS D3759-1 (ZN D3-1) AND 11.05 WAS 11.673 (ZN B7-3 & C7-3). REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS AND CORRECTED DIM IAW FIG 9a OF D359-907-1 REV. A.	MB	12.07.18
B	ADD QTY(2) D3759-1 BUSHING TO D3836-041/-042 (ZN D3-1, C6-2, C3-2, C6-3, C5-3, B6-3, B5-3). REASON: PAR10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	AP		
MFG. APPR.	ES		
APPROVED	MS		
DE APPR.	MS		
DATE	12.07.18		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

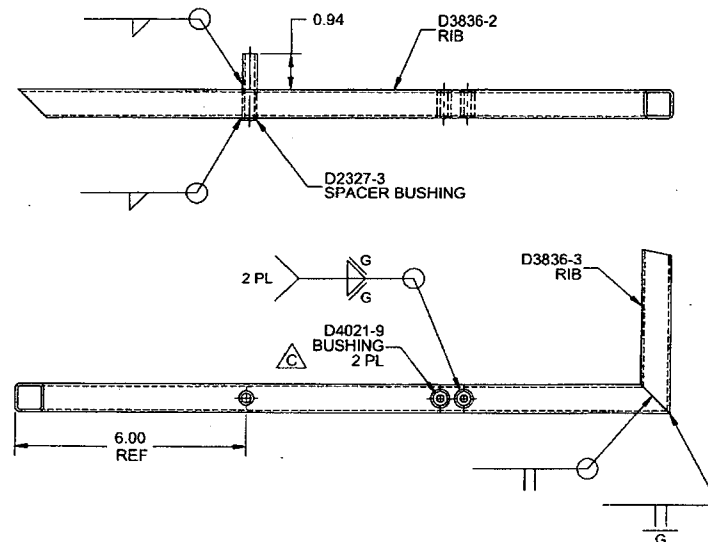
DRAWING NO. **D3836** REV. C  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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




**D3836-041 RIB ASSY (BASKET LID, LH)**



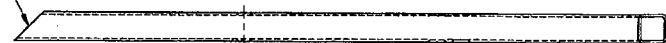
**D3836-042 RIB ASSY (BASKET LID, RH)**

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2012-08-03

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MFG. APPR.		<b>D3836</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET LID)</b>	NTS
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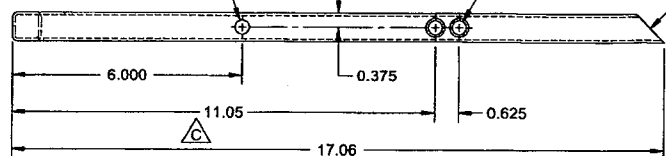
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CHAMFER



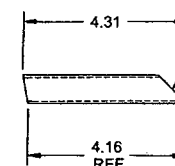
$\varnothing 0.375^{+0.020}_{-0.000}$  THRU

$\varnothing 0.375^{+0.020}_{-0.000}$  THRU  
 $\varnothing 0.49 \times 100^\circ$  CSINK  
2 PL, ON BOTH SIDES

0.75 X 45°  
CHAMFER



**D3836-1 RIB**



0.75 X 45°  
CHAMFER

**D3836-3 RIB**

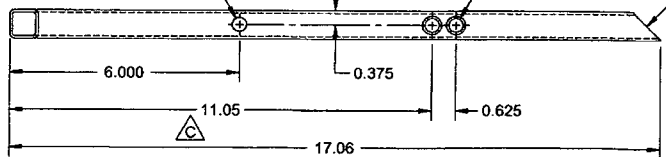
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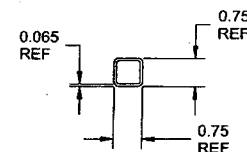
$\varnothing 0.375^{+0.020}_{-0.000}$  THRU

$\varnothing 0.375^{+0.020}_{-0.000}$  THRU  
 $\varnothing 0.49 \times 100^\circ$  CSINK  
2 PL, ON BOTH SIDES

0.75 X 45°  
CHAMFER



**D3836-2 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
2012-03-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/-2 = 0.77 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED	<i>A.P.</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>A.P.</i>	<b>D3836</b>	SHEET 3 OF 3
APPROVED	<i>INT</i>	TITLE	SCALE
DE APPR.	<i>INT</i>	<b>RIB ASSY (BASKET LID)</b>	NTS
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